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D044-715-011
Job Sheet 191470



Part No: D044-715-011

Job Qty: 2 pcs

Part Name: R44 Cargo Mirror



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/1/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3243 REV A, IIN-D044-715 REV A IPP Rev:A 04.02.18 New issue KJ/JLM IPP Rev:B 06-04-28
Manufactured on Water Jet JLM IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D 11.05.04
remove FE-032-EF DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Packaging 1 - Pick Kit	2 pcs	3/15/19		0.00	0.00	Packaging 1 - 1	
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
							Packaging 1 - 6	
							Packaging 1 - 7	
							Packaging 1 - 8	
							Packaging 1 - 9	
							Packaging 1 - 10	
							Packaging 1 - 11	
							Packaging 1 - 12	
							Packaging 1 - 13	
							Packaging 1 - 14	
							Packaging 1 - 15	
							Packaging 1 - 16	
							Packaging 1 - 17	
							Packaging 1 - 18	
							Packaging 1 - 19	
							Packaging 1 - 20	
							Packaging 1 - 21	
							Packaging 1 - 22	
							Packaging 1 - 23	
							Packaging 1 - 24	
							Packaging 1 - 25	
							Packaging 1 - 26	
							Packaging 1 - 27	
							Packaging 1 - 28	
							Packaging 1 - 29	
							Packaging 1 - 30	



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Container No: S166735



Part: D044-715-011

Job No: 191470

Serial No/Batch: S166735

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH04-17 Issue 1, FAA STC SR019371

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120 QC 4	2 pcs	3/15/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	DAS
					QC 4 - 69	MAR 2 7 2019 69
					QC 4 - 9	9-89
					QC 4 - 46	DAS
130 Packaging 3-1 - Stock - B4B	2 pcs	3/15/19	0.00 0.00		Packaging 3 - 1 - B4B	MAR 2 7 2019 69
					Packaging 3 - 2 - B4B	9-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
135 DC - 1 - B4B	2 pcs	3/15/19	0.00 0.00		DC - 1 - B4B	21
					DC - 2 - B4B	MAR 2 7 2019
140 QC 21 - FG	2 pcs	3/15/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-89 MAR 2 7 2019

Part Op 110 - (Pick Kit)

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D044-715-011

LOCATION: FG011

135 - (Document Control) Photocopy bluefile & type labels per PPPD044-715-011 CHG003

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
ALS4-1032-130	Rivnut	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5007279
AN3-4A	Bolt	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5149178
AN526C1032R10	Screw	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5071664
D1048 GA124	Clamp	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5114661
D1049 GA124	Saddle	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5152184
D2010-104	Arm	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5106444
D2011-101	Mirror 6"	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5142085
D3243-041	Bracket	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5104738
NAS1149D0332J	Washer	8 Ea (4 ea)	110-Packaging 1 - Pick Kit	5135473

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	ALS4-1032-130	8	9,354	0
	AN3-4A	8	332	0
	AN526C1032R10	8	65	0
	D1048	4	18	0
	D1049	4	20	0
	D2010-104	2	2	0
	D2011-101	2	29	0
	D3243-041	2	4	0
	NAS1149D0332J	8	3,083	0

Part Specifications

Specifications could not be found.

Plex 3/1/19 11:38 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

REFERENCE ONLY

32.2 CARGO MIRROR REMOVAL

- 32.2.1 Remove the AN3 bolts securing the D3243-041 Bracket to the skidtube and remove the Cargo Mirror.
- 32.2.2 Reinstall the AN3-4A bolts in the inserts. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kp 0.63 m-kp	32.0 in 0.81 m	41.6 in-lb 0.48 m-kp

32.4 PARTS LIST

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

REFERENCE ONLY

TC Accepted

MAR 31 2004

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Change Record

Part Number DO44-715-011
Description 244 CARGO MIRROR

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